

Work Order ID 117601

Monday, April 28, 2014 1:44:01 PM

117601

Page 1

Item ID: D2855-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap 34 42
 Start Date: 4/28/2014 Start Qty: 50.00 ***50*** 39 Cust Item ID:
 Required Date: 5/19/2014 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: CZ Date: 14/04/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	Rev B								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>24003</u>								
	Cast per Dwg D2855								
	Material Release Note Required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 4/06/13

AUTH u

Certs

FILED

DATE

4/06/13

Work Order ID 117601

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117601

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Item ID: D2855-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 4/28/2014 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 5/19/2014 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Cut to length as per dwg 4- Deburr	0.00 0.00				(33)	mm	17/06/19	
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				33			DAS 34 9-89
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OS1005 4.3-Alum Memo START TIME: 1:50 OVEN TEMPERATURE: 320° FINISH TIME: 2:00	0.00 0.00				33		14-6-24	DAS 34 9-89

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Accept

Setup Start *NS1*

Stop *NS2*

50

Cust Item ID:

Start Date: 4/28/2014 **Start Qty:** 50.00

Required Date: 5/19/2014 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

MF
14-7-4

Picklist Print

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Page 1

Work Order ID: 117601

117601

Parent Item: D2855-3

D2855-3

Parent Item Name: Cap

Start Date: 4/28/2014

Required Date: 5/19/2014

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No			170	Each	1,177.000	2	100	66		

AI S7-1032-225 X

Insert

**

ALS4-1032-225

Location

Loc Qty

Loc Code

FG

80

118520

80

FP001

1000

m128649

1000

ST280

97

X66

m128179

97

D2855P

Purchased

No

110

Each

0.0000

1

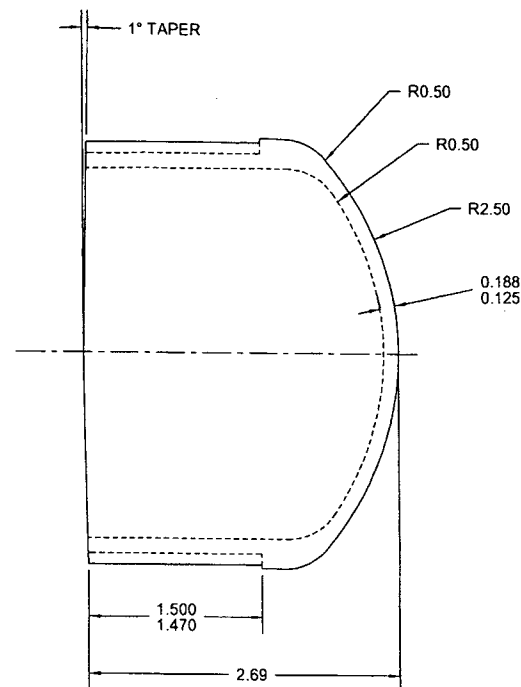
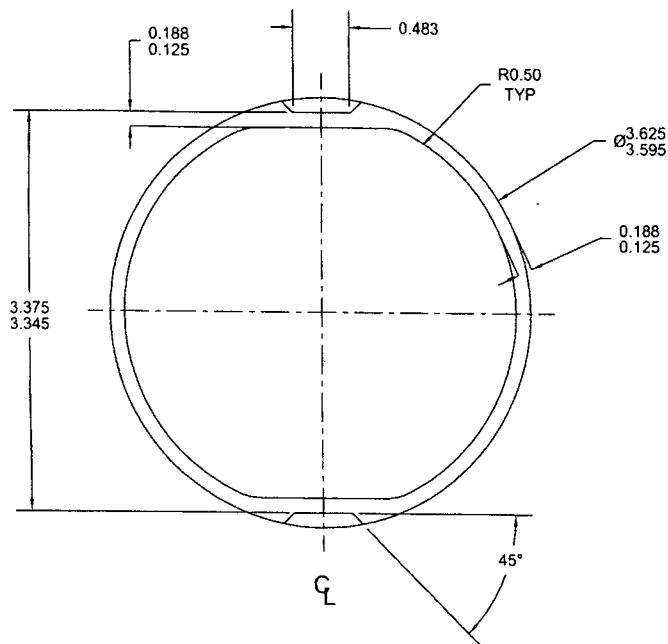
50

D2855P

**

Cap

CD 14/06/02 30



D2855C CASTING DETAIL



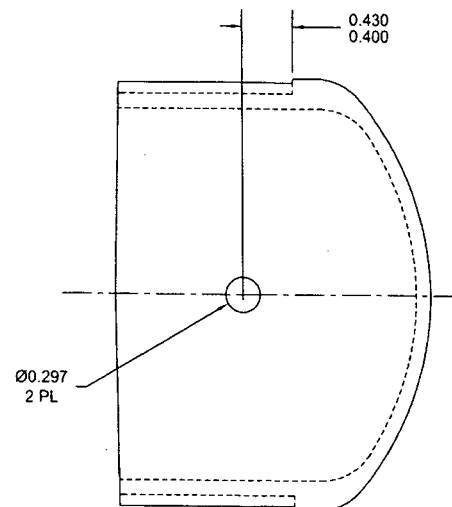
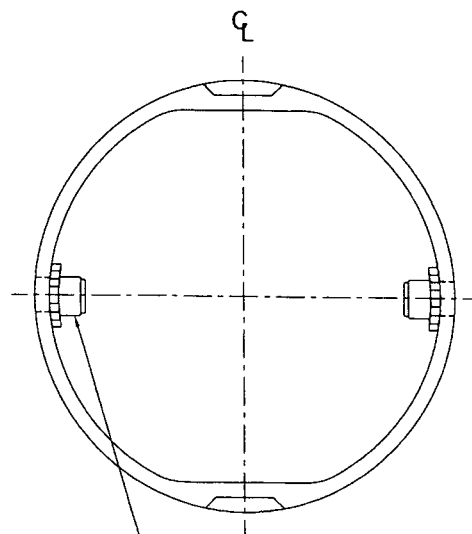
RELEASED
09/07/15 MJP

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

09/14/04/28
W10: 117601

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

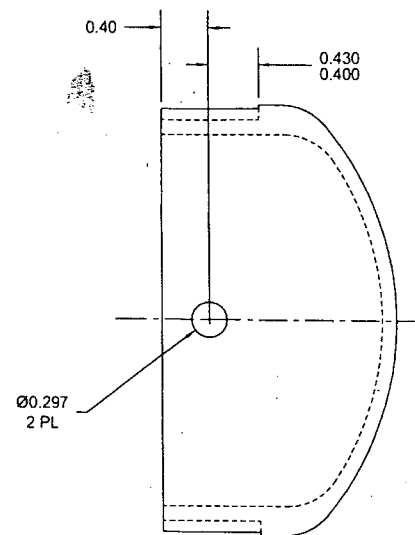
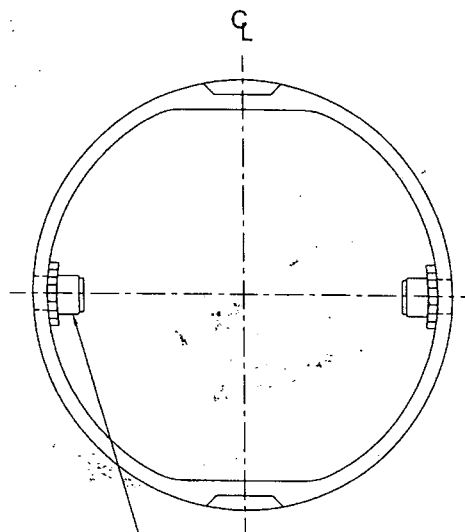
D2855 CAP
(MAKE FROM D2855C CASTING)

RELEASED
21/5/15

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EP	D2855	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	#	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP

(MAKE FROM D2855C CASTING)



RELEASED
24/7/15 MB

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 3 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24003

Purchase Order Date 4/29/2014

PO Print Date 5/1/2014

Page Number 1 of 2

Order From :

VC-MSY01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

METALLURGIE SYCA
500 PRINCIPALE

ST.DOMINIQUE, QUEBEC JOH 1LO

REVISED \$

Contact Name

Vendor Phone

450-261-0853

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

PAID
5/1/2014

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P	Cap	5/23/2014 Yes 5/23/2014		50.00 Each	\$12.50	\$625.00

CAST AS PER DWG D2855 REV. B
B117602

Nic 55

Line Total: \$625.00

2	D2855P	Cap	5/23/2014 Yes 5/23/2014		50.00 Each	\$12.50	\$625.00
---	--------	-----	-------------------------------	--	---------------	---------	----------

CAST AS PER DWG D2855 REV. B
B117601

14/06/02

10/1/13

Line Total: \$625.00

Note:

5/1/2014

N° D'ENR. DE TAXE
TAX REG. NO.

N° DE COMMANDE
ORDER NO.

VENDU À
SOLD TO

ADRESSE
ADDRESS

EXPÉDIÉ À
SHIP TO

ADRESSE
ADDRESS

DATE

30 Mai 2014

24003

Dart Aerospace Ltd

1270 ABERDEEN STREET

HAWKSBURY ONTARIO

K6A 1K7

DATE D'EXPÉDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDEUR
SALESPERSON

111

D-2855

1 BOXE X 55 PCS X 30 POUNDS

1 BOX X 56 PCS X 31 POUNDS

Transport Fedex

Thanks for your support

TOTAL

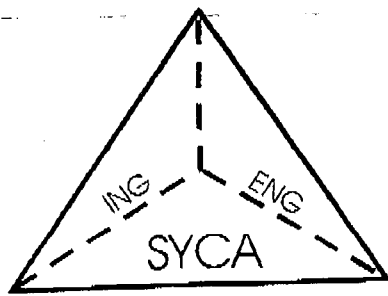
931352

SIGNATURE

Blueline DCB27

FORMULAIRE DE VENTE - SALES ORDER

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MÉTALLURGIE SYCA Inc.

500, Principale
St-Dominique, Québec
J0H 1L0

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

WWW.SYCA-INC.COM

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2014-05-30

SHIPPING MEMO: 931125

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	111	D-2855	24003

All item specify in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ21052014

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

-VISUAL INSPECTION: DONE

-DIMENSIONNAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

RESPONSIBLE: CARL JOBIN ING.

SA-101